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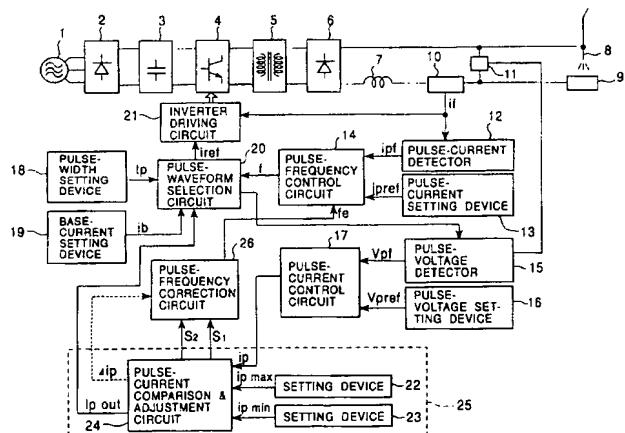
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(54) Pulse arc welding apparatus

(57) An pulse arc welding apparatus feeds a consumable electrode (8) with a constant rate, and arc-welds by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic between the consumable electrode (8) and a workpiece (9). A pulse current control circuit (17) outputs a pulse current command value, based on a difference signal between a pulse voltage detector (15) and a pulse voltage setting device (16). A pulse frequency control circuit (14) outputs a pulse frequency command value, based on a difference signal between a pulse current detector (12) and a pulse current setting device (13). Setting devices (22,23) which output a pulse current upper limit value or lower limit value are provided. A pulse current comparison and adjustment circuit (24) inputs a pulse current command value and a pulse current upper limit value or a pulse current lower limit value, and outputs the pulse current upper limit value, when the pulse current command value is larger than an upper limit value of a pulse current, and/or outputs the pulse current lower value when the pulse current command value is less than a lower limit value of the pulse current, and outputs the pulse current command value in a case except the above. The pulse frequency correction circuit (26) outputs a frequency correction value f_e to the pulse frequency control circuit, such that when the pulse cur-

rent upper limit value or lower limit value is selected continuously in a predetermined number of times at the pulse current comparison and adjustment circuit (24), the pulse frequency is increased/decreased by a predetermined value Δf by Δf in accordance with the selected number of times.

FIG. 1



Description**BACKGROUND OF THE INVENTION****1. Field of the Invention**

The present invention relates to a pulse arc welding apparatus for arc-welding by feeding a consumable electrode to a workpiece (a part to be welded) with a constant rate, and applying a welding current between the consumable electrode and the workpiece.

2. Description of the Related Art

A pulse arc welding method for welding by feeding a consumable electrode with a constant rate implements a welding by superimposing a pulse current equal to or more than a critical current value which is called a transition current, on a base current of maintaining an arc.

In the pulse arc welding method, such welding cases of combining workpieces of different plate thicknesses and of combining workpieces of different materials are increasing. Also, in the welding apparatus, an automation of welding by a robot or an automatic-machine is highly increasing, and thus it is needed a technology of controlling the welding conditions (such as a current, a voltage, a travel speed, etc.), in a preset or in a real-time, in response to a change of a joint of the workpiece, by a combination of visionsensors and the likes.

Recently, in a welding procedure of a welding system of which the robot and various sensors are combined, the procedure of welding by changing the welding conditions to equal to or more than that of the conventional welding procedure, according to the changes of plate thicknesses, materials and gapes, in one of successive welding joints, are increasing. Accordingly, it is necessary to stabilize promptly to an arc length which is suited to the conditions when changing the set values of the welding conditions, and in addition, for a wire stick-out length which changes relatively according to the plate thickness and the joint shape, a necessity of keeping it to a proper arc length is increasing. That is, it is needed that a responsibility of the arc length control is to be fast.

The applicant of the present application has already proposed the technology to highly increase a responsibility of the arc length control in the pulse arc welding (Japanese Unexamined Patent Publication No. 5-23850). In this prior art, as shown in Figs. 1 and 3 thereof, in order to ensure a stable weld of one pulse-one droplet transfer, setting an upper limit value and a lower limit value of a pulse current with a constant voltage characteristic, and when the arc length has been changed suddenly, in a case of being an extremely short or long arc length as to be reached to the upper limit value or the lower limit value, based on a difference

signal between the set value and the detected value of the pulse current, in addition to a control of increasing/decreasing a pulse frequency f , increasing/decreasing a predefined value Δf in the pulse frequency f , and increasing an variational range of an average current value, thereby highly increasing the responsibility of the arc length control.

However, in the modern welding procedure, a large fluctuation in the welding condition set value or in the wire stick-out length can not be compensated by only increasing/decreasing the predefined value Δf in the pulse frequency, as described in the above mentioned pre-filed patent application, and it will take too much time until a proper arc length can be achieved. For this reason, in a case that the arc length is long, a welding beads will be dented, and a concentration of the arc will be vanished, and thereby there exists the weak points such that the beads are broken off, and the deflection beads occur. Also, in a case that the arc length is short, the welding beads will be too conveyed, and the arc shortage will occur, or the burn-through will occur for thin workpieces. In either case, it has been very difficult to obtain a good welding result.

25 SUMMARY OF THE INVENTION

Accordingly, it is an object of the present invention to provide a pulse arc welding apparatus capable of substantially increasing a responsibility of an arc length control, and enabling to follow a change of a welding condition and a fluctuation of the distance between a contact tip and a workpiece promptly.

The pulse arc welding apparatus according to the present invention includes, in a pulse arc welding apparatus for arc-welding by feeding a consumable electrode with a constant rate, and by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic between the consumable electrode and a workpiece:

- 45 a pulse voltage detecting means for detecting a pulse voltage;
- 50 a pulse voltage setting means for setting a pulse voltage;
- 55 a pulse current control means for outputting a pulse current command value, based on a difference signal between the pulse voltage detecting means and the pulse voltage setting means;
- a pulse current detecting means for detecting a pulse current;
- a pulse current setting means for setting a pulse current;
- a pulse frequency control means for outputting a pulse frequency command value, based on a difference signal between the pulse current detecting means and the pulse current setting means;
- a pulse current upper and lower limit values setting

means for outputting a pulse current upper limit value and/or lower limit value; a pulse current comparison and adjustment means for inputting a pulse current command value and a pulse current upper limit value and/or a pulse current lower limit value, and for outputting the pulse current upper limit value, when the pulse current command value is larger than an upper limit value of a pulse current, and/or the pulse current lower limit value when the pulse current command value is less than a lower limit value of the pulse current, and for outputting the pulse current command value in a case except the above; and a pulse frequency correction means for outputting a frequency correction value f_e to the pulse frequency control means, such that when the pulse current upper limit value or lower limit value is selected continuously in a predetermined number of times at the pulse current comparison and adjustment means, the pulse frequency is increased/decreased by a predetermined value Δf in accordance with the selected number of times.

In this pulse arc welding apparatus, it can be constituted as including:

a pulse frequency reference value setting means for outputting a pulse frequency reference value corresponding to a wire feed rate; and a pulse frequency adding means for adding the pulse frequency reference value and a pulse frequency command value which is an output of the pulse frequency control means, and for outputting a pulse frequency added value f .

Further, it can be constituted as, the predetermined value Δf is a value which corresponds to an amount of either one of the pulse frequency reference value or the pulse frequency added value.

Further, it can be constituted as, the predetermined value Δf is a value which corresponds to a difference between the pulse current command value and the pulse current upper limit value, the pulse current lower limit value, or an output value of the pulse current setting means.

The second pulse arc welding apparatus includes, in an AC pulse arc welding apparatus for feeding a consumable electrode with a constant rate, for arc-welding by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic and a straight polarity current between the consumable electrode and a workpiece:

a pulse voltage detecting means for detecting a pulse voltage; a pulse voltage setting means for setting a pulse voltage;

5 a pulse current control means for outputting a pulse current command value, based on a difference signal between the pulse voltage detecting means and the pulse voltage setting means;

10 a pulse current detecting means for detecting a pulse current and a pulse current setting means for setting a pulse current;

15 a pulse frequency control means for outputting a pulse frequency command value, based on a difference signal between the pulse current detecting means and the pulse current setting means;

20 a pulse current upper and lower limit values setting means for outputting a pulse current upper limit value and/or lower limit value;

25 a pulse current comparison and adjustment means for inputting a pulse current command value and a pulse current upper limit value and/or a pulse current lower limit value, and for outputting the pulse current upper limit value, when the pulse current command value is larger than an upper limit value of a pulse current, and/or the pulse current lower limit value when the pulse current command value is less than a lower limit value of the pulse current, and for outputting the pulse current command value in a case except the above; and

30 a pulse frequency correction means for outputting a frequency correction value f_e to the pulse frequency control means, such that when the pulse current upper limit value or lower limit value is selected continuously in a predetermined number of times at the pulse current comparison and adjustment means, the pulse frequency is increased/decreased by a predetermined value Δf in accordance with the selected number of times.

35 In this pulse arc welding apparatus, it can be constituted as including:

40 a pulse frequency reference value setting means for outputting a pulse frequency reference value corresponding to a wire feed rate and a straight polarity ratio; and

45 a pulse frequency adding means for adding the pulse frequency reference value and a pulse frequency command value which is an output of the pulse frequency control means, and for outputting a pulse frequency added value f .

50 It can be constituted as, the predetermined value Δf is a value which corresponds to an amount of either one of the pulse frequency reference value or the pulse frequency added value.

Further, it can be constituted as, the predetermined value Δf is a value which corresponds to a difference between the pulse current command value and the pulse current upper limit value, the pulse current lower limit value, or an output value of the pulse current setting means.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a block diagram showing the first embodiment of the pulse arc welding apparatus according to the present invention;

Fig. 2 is a waveform diagram showing the waveforms of the pulse arc welding apparatus of Fig. 1; Fig. 3 is a waveform diagram showing other waveforms of the pulse arc welding apparatus of Fig. 1.; Fig. 4 is a waveform diagram showing a variation of the waveforms of the pulse arc welding apparatus of Fig. 1;

Fig. 5 is a block diagram showing the second embodiment of the pulse arc welding apparatus according to the present invention;

Fig. 6 is a graphic diagram illustrating the operation of the pulse arc welding apparatus of Fig. 5;

Fig. 7 is a block diagram showing the third embodiment of the pulse arc welding apparatus according to the present invention;

Fig. 8 is a waveform diagram showing the waveforms of the pulse arc welding apparatus of Fig. 7; and

Fig. 9 is a graphic diagram illustrating the operation of the pulse arc welding apparatus of Fig. 7.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

With reference to the accompanying drawings, the preferred embodiments of the pulse arc welding apparatus according to the present invention will be described concretely in detail. Fig. 1 is a block diagram showing an apparatus to be used in the first embodiment of the present invention, a power supply 1, rectifiers 2, 6, a smoothing capacitor 3, an inverter 4, a down transformer 5, and a DC reactor 7 have the similar structures as the ones of the well-known inverter-type welder (welding machine).

A current detector 10 of an output control circuit is connected in series, between the DC reactor 7 and a workpiece 9, as well as a voltage detector 11 is connected in parallel between the workpiece 9 and a consumable electrode 8.

A current value i_f detected by the current detector 10 is input to the inverter driving circuit 21, as well as is input to a pulse current detector 12, and a voltage value v_f detected by the voltage detector 11 is input to a pulse voltage detector 15. The pulse current detector 12 obtains an average value during a pulse period by inputting a detected value i_f , and outputs this as a pulse current detected value i_{pf} to a pulse frequency control circuit 14. Also, to the pulse frequency control circuit 14, a set value i_{pref} of the pulse current from a pulse current setting device 13 is input. The pulse frequency control circuit 14 outputs a pulse frequency command value f to a pulse waveform selection circuit 20, based on a difference between these detected value i_{pf} and set value

i_{pref} .

On the other hand, the pulse voltage detector 15 inputs a detected value v_f of the voltage detector 11 and then outputs a pulse voltage detected value v_{pf} during a pulse period to a pulse current control circuit 17 according to a signal of the pulse waveform selection circuit 20 which will be described later. The pulse voltage setting device 16 outputs a set value v_{pref} of the pulse voltage. The pulse current control circuit 17 which inputs these pulse voltage detected value v_{pf} and pulse voltage set value v_{pref} obtains a pulse current command value i_p which is an amplified difference signal between these detected value v_{pf} and the set value v_{pref} of this pulse voltage, and outputs this to a pulse current comparison & adjustment circuit 24 of a pulse current clamp circuit 25 which will be described later.

Further, to this pulse waveform selection circuit 20, a set value t_p of a pulse width output from the pulse width setting device 18 and a set value i_b of a base current output from the base current setting device 19 are input. Then, the pulse waveform selection circuit 20 selects, based on the set value t_p of the pulse width and the command value f of the pulse frequency, the command value i_p of the pulse current during the pulse period T_p and the set value i_b of the base current during the base period T_B , and outputs the selected value to an inverter driving circuit 21 as a current command value i_{ref} . The inverter driving circuit 21 controls the inverter 4 such that the current detected value i_f and the current command value i_{ref} are matched.

Then, the pulse current clamp circuit 25 and the pulse frequency correction circuit 26 are connected between the pulse current control circuit 17 and the pulse waveform selection circuit 20. The pulse current clamp circuit 25 is constituted of a pulse current upper limit value setting device 22 for outputting an upper limit value i_{pmax} of a control pulse current, a pulse current lower limit value setting device 23 for outputting a lower limit value i_{pmin} of the pulse current, and the pulse current comparison and adjustment circuit 24. Herein, it is effective to provide either one of the pulse current upper limit value setting device 22 or the pulse current lower limit value setting device 23.

An output i_{pout} of the pulse current comparison and adjustment circuit 24 is input to the pulse waveform selection circuit 20. Then, an output f_e of the pulse frequency correction circuit 26 is input to the pulse frequency control circuit 14.

In a case that the arc length is elongated and i_{pmin} is selected as the i_{pout} , the pulse current comparison and adjustment circuit 24 is synchronized with the pulse current period and outputs a pulse signal S_1 of one shot, to the pulse frequency correction circuit 26. Assuming that i_{pmin} is selected continuously as i_{pout} , it turns to be the pulse signal S_1 which is continuous for each period of the pulse current.

The pulse frequency correction circuit 26 outputs a frequency correction value f_e for the pulse frequency

control circuit 14, until the signal S_1 vanishes after the third round, in a case that the i_{pmin} is selected consecutively predetermined times, for instance twice, by counting the pulse signal S_1 . This value of the frequency correction value f_e should be a value such that the predetermined value Δf is subtracted for each pulse period.

In the control apparatus as constituted above, a pulse waveform to be fed to the consumable electrode 8 turns to be as shown in Fig. 2(a). In the pulse period T_p , a pulse current command value i_p is output to the inverter driving circuit 21 as the i_{ref} by the pulse waveform selection circuit 20. Therefore, the inverter 4 is driven by the pulse current command value i_p such that a predetermined pulse voltage set value v_{pref} and a pulse voltage detected value v_{pf} are matched. Because of this, the pulse voltage V_p turns to be an external characteristic of a constant voltage characteristic. On the other hand, during the base period T_B , a base current set value i_b is provided to the inverter driving circuit 21 by the pulse waveform selection circuit 20. Because of this, the inverter 4 is controlled by a predetermined base current set value i_b . For this reason, the base current I_b turns to be an external characteristic of a constant current characteristic.

Then, in a case that the arc length is shortened, for keeping the pulse voltage V_p , the pulse current I_p increases instantaneously, and in a case that the arc length is elongated suddenly, the pulse current I_p decreases instantaneously.

As a compensation for a relatively slow variation of the arc length and a compensation for an adaptivity of a feed rate and a molten rate of the consumable electrode, based on a difference signal between the pulse current detected value i_{pf} and a predetermined pulse current set value i_{pref} , the pulse frequency f is controlled. For example, in a case that the detected value i_{pf} is larger than the set value i_{pref} when the arc length is too short, by increasing the average current with enlarging the frequency command value f , increasing the molten rate of the consumable electrode and thereby elongating the arc length. Because of this, the detected value i_{pf} become smaller as a result. Conversely, in a case that the detected value i_{pf} is smaller than the set value i_{pref} when the arc length is too long, by decreasing the average current with making the frequency command value f small, decreasing the molten rate of the consumable electrode and thereby shortening the arc length. Because of this, the detected value i_{pf} becomes larger as a result.

Such as this, by adjusting the pulse frequency f and then by controlling it in such a manner that the i_{pf} matches with the i_{pref} , the pulse current I_p turns to be a roughly constant value.

Because of this, an energy of one pulse-one melting/dropping is secured, thereby a stable transfer of one pulse-one droplet is implemented. Also, by changing the average current, the matching with a feed rate of the consumable electrode can be made by controlling the

molten rate. Further, turning the pulse current I_p in the pulse voltage V_p to be a roughly constant indicates to control such that the arc resistance turns to be a predetermined value, and the arc length turns to be a constant.

Then, in a case that the arc length is elongated and the i_{pmin} is selected as the command value i_{pout} , as shown in Fig. 2, the pulse current comparison and adjustment circuit 24 synchronizes with the pulse current period and outputs the pulse signal S_1 of one shot, for the pulse frequency correction circuit 26. If the i_{pmin} is selected continuously as the i_{pout} , it turns to be the pulse signal S_1 which is continuous for each period of the pulse current. The pulse frequency correction circuit 26 outputs the frequency correction value f_e , for the pulse frequency control circuit 14, until the signal S_1 vanishes after the third round, in a case that the i_{pmin} is selected continuously for a predetermined times, for instance 2 times, by counting the pulse signal S_1 . A value of this f_e is taken to be a value from which a predetermined value Δf is subtracted for each pulse period.

According to this, comparing with a method of making the pulse frequency small only with a predetermined value Δf in a case that the wire stick out length is quickly elongated, and the arc length is extremely elongated, it becomes possible to lower the average current rapidly, in order to further make it small with an amount of a pulse frequency $n \times \Delta f$, where n is a number of times the i_{pmin} being selected when the arc length is still longer thereafter, thereby it can be quickly returned from a state of which the arc length is long to a proper length.

The one described above is an operation when the arc length turns to be elongated, but conversely, in a case that the arc length is shortened and the i_{pmax} is selected as the i_{pout} , as shown in Fig. 3, the pulse current comparison and adjustment circuit 24 outputs the pulse signal S_2 of one shot. The pulse frequency correction circuit 26 outputs the frequency correction value f_e until the signal S_2 vanishes after the third round by counting the pulse signal S_2 , and a value of this f_e is taken to be a value which adds a predetermined value Δf for each pulse period. According to this, it becomes possible to raise the average current rapidly, in order to further make it large with an amount of a pulse frequency $n \times \Delta f$, where n is a number of times the i_{pmin} being selected, when the wire stick-out length is rapidly shortened, thereby it can be quickly returned from a state of which the arc length is short to a proper length.

In the present embodiment, a responsibility of the arc length is enhanced by lowering the frequency rapidly when the i_{pmin} is selected, and further by raising the frequency rapidly when the i_{pmax} is selected. When the i_{pmin} succeeds and a long state of the arc length continues, because of the vanishing of the arc concentration, the deflection in the beads could be easily occurred as the arc jumps to the thin plate side of which a heat capacity is small and a temperature is high at a time of welding a joint of which the plate thicknesses are differ-

ent.

Also, When the $I_{p\max}$ succeeds and a short state of the arc length continues, according to this high pulse current, a burn-through could occur easily at a thin plate welding. For this reason, in order to prevent the deflection of the beads of the workpiece, of which the heat capacities are different, an effect of reducing control of the frequency at a time of the $I_{p\min}$ selection is remarkable, and for a prevention of burn-through at a time of welding the thin plate, an effect of raising control of the frequency at a time of selecting the $I_{p\max}$ appears clearly.

As such, although it is a control for either one of these, it could have a sufficient effect depending on a workpiece.

In a case that the arc generation point on the workpiece side is not stabilized (a phenomena of which the arc crawls around because the cathode ray point is not stabilized), an electric resistance of the arc quickly changes and the $I_{p\min}$ or the $I_{p\max}$ is selected. At that time, if the frequency is corrected, it would grow an unstable condition. When the number of times for S_1 or S_2 from an occurrence of the signal S_1 to an output of the correction value f_e is set to be 3 times as mentioned above, this problem could occur.

In order to prevent this, a correction of the frequency is implemented actually, after having confirmed that the arc length is to be long or to be short, continuously with the predetermined times. It is desirable that this predetermined times could be set an arbitrary numbers of 1 to 10 times mainly according to the materials of wire and workpiece and the shielding gas.

Further, by adding an error amplifier within the pulse current comparison and adjustment device 24, it could add Δi_p which is a difference signal between the $i_{p\min}$ or the $i_{p\max}$ and the i_p in addition to the signal S_1 of the first embodiment. This difference signal Δi_p is shown with a dotted line in Fig. 1. The pulse frequency correction circuit 26 operates $\Delta f_{1\dots n}$ proportional to these difference signals $\Delta i_{p1\dots n}$. For this, a frequency correction value f_e of an output of the pulse frequency correction circuit 26 is the value from which $\Delta f_{1\dots n}$ proportional to the difference signals $i_{p1\dots n}$ is subtracted for each pulse period, as shown in Fig. 4.

Since an actual arc length would be shorter as a difference Δi_p between the pulse command value and the pulse lower limit value being larger, the frequency correction value f_e would lower the pulse frequency in great extent by making a predetermined value Δf large in accordance with this difference Δi_p , thereby the responsibility will be improved comparing with the first embodiment. Further, a similar effect will be obtained by using the pulse current set value i_{pref} , instead of the pulse current lower limit value $i_{p\min}$.

Next, the second embodiment of the pulse arc welding apparatus according to the present invention will be described by referring to the block diagram of Fig. 5. In the first embodiment, the pulse frequency f is

determined on a basis of the difference between the pulse current detected value i_{pf} and the set value i_{pref} . The pulse frequency f is roughly expressed as a function of a feed rate only, if the wire material and wire diameter are determined. In this first embodiment, for outputting the f from the difference between the i_{pf} and the i_{pref} , a gain of the pulse frequency control circuit 14 needs to be large, thereby an oscillation at a steady time could occur easily.

In the second embodiment shown in Fig. 5, a frequency setting device 33 inputs a signal of a wire feed rate setting device 32, and then sets a pulse frequency reference value f_{ref} proportional to the feed rate. An adder 34 adds this f_{ref} and the output f_c of the pulse frequency control circuit 14, and then outputs a pulse frequency f of the welding output to be output actually. This pulse frequency f is input to the pulse waveform selection circuit 20. A set value of the wire feed rate setting device 32 is also input to the wire feed motor control circuit 31, and controls the wire feed motor 30 on a basis of the set value. This wire feed motor 30 feeds the consumable electrode 8.

According to the present embodiment, the f_c only needs to be a deviation between the pulse frequency reference value f_{ref} and a proper pulse frequency f which is slightly different in accordance with a joint shape, a plate thickness, a travel speed, and the like. Thus the gain of the pulse frequency control circuit 14 can be small, thereby preventing an oscillation at the steady time.

Also, as shown in Fig. 6, when the set value of the wire feed rate is changed from W_1 to W_2 suddenly, in order to cope with a welding joint such that a plate thickness of the workpiece is thickened on the halfway, an operation point would shift from a point A to a point B, if the proper pulse frequencies for each feed rates W_1 and W_2 are, for example, f_1 and f_2 , respectively.

According to the circuit of the present embodiment shown in Fig. 5, in this process of shifting from the point A to the point B, the pulse frequency reference value f_{ref} is changed from f_{ref1} to f_{ref2} as the set value of the wire feed rate changing from W_1 to W_2 , as well as the output f_c of the pulse frequency control circuit would be quickly controlled from f_{c1} to f_{c2} by the operations of the pulse frequency control circuit 14 and the pulse frequency correction circuit 26, as described in the first embodiment. Therefore, the pulse frequency f_1 is quickly changed to the pulse frequency f_2 which is suitable for the feed rate W_2 . As a result, even if the wire feed rate is changed in large, it is instantaneously adjusted to an arc length suitable for each wire feed rate.

Next, an alternative example of the present embodiment will be described. In Fig. 5, as shown in dotted lines, outputting the frequency reference value f_{ref} from the frequency setting device 33 to the pulse frequency correction circuit 26, the predetermined value Δf within this pulse frequency correction circuit 26 is to be set such that when the f_{ref} is large the Δf should be a large

value. In this case, when the wire feed rate is large and the f_{ref} is large, then the pulse frequency correction value f_e would be large also, so that the responsibility of the pulse frequency would be improved, comparing with a case of the Δf being a constant.

Next, the third embodiment in a case that the present invention is applied to a pulse arc welding apparatus of an alternate current will be described. Fig. 7 differs in the points that it is provided with a second inverter 26, a polarity switch control circuit 27, a straight polarity current setting device 28, a polarity ratio setting device 40 and a straight polarity period arithmetic device 41, with respect to Fig. 5 of the second embodiment of the present invention. The second inverter 26 is connected in parallel between the consumable electrode 8 and the workpiece 9. Also, a command value f of a pulse frequency, a set value t_p of a pulse width and a set value T_{EN} of a straight polarity period are input to the polarity switch control circuit 27. This polarity switch control circuit 27 outputs a polarity switch signal P_e , such that a predetermined period T_{EN} of a straight polarity is entered into a base period T_B , based on this command value f and a pulse width command value t_p . At the same time, the polarity switch control circuit 27 drives the second inverter 26, such that an alternate current is applied between the consumable electrode 8 and the workpiece 9.

Further, the pulse current command value i_{ref} which is an output of the pulse waveform selection circuit 20 is input to the inverter driving circuit 21, and is fed to the inverter 4. While the straight polarity current command value i_{en} output from the straight polarity current setting device 28 is input to the pulse waveform selection circuit 20, and the polarity switch signal P_e indicates a straight polarity side, the command value i_{en} is to be selected, as a current designated value i_{ref} .

According to this configuration, a current waveform to be output turns to be one as shown in Fig. 8, and external characteristics of a constant voltage characteristic during the T_p period, and a constant current characteristic during the T_B period can be obtained.

The straight polarity period T_{EN} is determined in such a manner that the command value t_{en} during the straight polarity period is so operated as to be $\gamma = i_{en} \times t_{en} / (i_{pref} \times t_p + i_{en} \times t_{en})$, by inputting into the straight polarity period arithmetic device 41, a ratio γ set by the straight polarity ratio setting device 40, the command value t_p of the pulse width, the set value i_{pref} of a pulse peak current, and the command value i_{en} of the straight polarity current.

In the present embodiment, in case of increasing/decreasing the average current, in accordance with a difference signal between the detected value and the set value of the pulse current, the arc length is controlled by increasing/decreasing the pulse frequency f (the T_{EN} is fixed, and the T_B-T_{EN} is varied).

Although it is the same as the second embodiment (Fig. 5) such that the frequency command value f is a

sum of the pulse frequency reference value f_{ref} and the output f_c of the pulse frequency control circuit 14, a signal of the ratio γ is input from the straight polarity ratio setting device 40 to the pulse frequency setting device 33. Since, by setting the ratio of the straight polarity larger, the average current could be small although the wire feed rate is the same, the pulse frequency would be made small. Therefore, the pulse frequency setting device 33 is, in advance, provided with a function of the pulse frequency reference value f_{ref} as indicated by the solid line in Fig. 9 in response to the wire feed rate w and the straight polarity ratio γ .

In this Fig. 9, the gap of the welding joint turns to be large on the halfway. Therefore, the operation point will shift from the point C to the point D, if the proper pulse frequencies for each straight polarity ratio γ_1, γ_2 are, for example, f_3, f_4 , respectively in case of setting the straight polarity ratio γ larger from the γ_1 to the γ_2 of Fig. 9.

According to the present embodiment, in the process of shifting from this point C to the point D, when the setting of the ratio changes from the γ_1 to the γ_2 , the pulse frequency reference value would be changed from the f_{ref3} to the f_{ref4} , as well as the outputs f_c of the pulse frequency control circuit 14 is rapidly controlled from the f_{c3} to the f_{c4} , by an operation of the pulse frequency control circuit 14 and the pulse frequency correction circuit 26. As a result of this, the arc length can be adjusted instantaneously so as to be suitable for each polarity ratio, even though changing the polarity ratio in large.

As described above, according to the present invention, the pulse frequency correction means is provided which outputs the frequency correction value f_e to the pulse frequency control means, such that the pulse frequency is increased/decreased with a predetermined value Δf by a predetermined value Δf in accordance with a selected number of times when the upper limit value or the lower limit value of the pulse current is selected continuously with a predetermined number of times. Therefore, the responsibility of the arc length control can be substantially enhanced, and the arc length control can quickly follow the change of the welding condition and a fluctuation of the distance between a contact tip and a workpiece.

An pulse arc welding apparatus feeds a consumable electrode with a constant rate, and arc-welds by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic between the consumable electrode and a workpiece. A pulse current control circuit outputs a pulse current command value, based on a difference signal between a pulse voltage detector and a pulse voltage setting device. A pulse frequency control circuit outputs a pulse frequency command value, based on a difference signal between a pulse current detector and a pulse current setting device. Setting devices which output a pulse current

upper limit value or lower limit value are provided. A pulse current comparison and adjustment circuit inputs a pulse current command value and a pulse current upper limit value or a pulse current lower limit value, and outputs the pulse current upper limit value, when the pulse current command value is larger than an upper limit value of a pulse current, and/or outputs the pulse current lower value when the pulse current command value is less than a lower limit value of the pulse current, and outputs the pulse current command value in a case except the above. The pulse frequency correction circuit outputs a frequency correction value f_e to the pulse frequency control circuit, such that when the pulse current upper limit value or lower limit value is selected continuously in a predetermined number of times at the pulse current comparison and adjustment circuit, the pulse frequency is increased/decreased by a predetermined value Δf by Δf in accordance with the selected number of times.

Claims

1. A pulse arc welding apparatus for arc-welding by feeding a consumable electrode with a constant rate, and by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic between the consumable electrode and a workpiece, comprising:

a pulse voltage detecting means for detecting a pulse voltage;
 a pulse voltage setting means for setting a pulse voltage;
 a pulse current control means for outputting a pulse current command value, based on a difference signal between said pulse voltage detecting means and said pulse voltage setting means;
 a pulse current detecting means for detecting a pulse current;
 a pulse current setting means for setting a pulse current;
 a pulse frequency control means for outputting a pulse frequency command value, based on a difference signal between said pulse current detecting means and said pulse current setting means;
 a pulse current upper and lower limit values setting means for outputting a pulse current upper limit value and/or lower limit value;
 a pulse current comparison and adjustment means for inputting a pulse current command value and a pulse current upper limit value and/or a pulse current lower limit value, for outputting said pulse current upper limit value, when said pulse current command value is larger than an upper limit value of a pulse cur-

rent, and/or said pulse current lower limit value when said pulse current command value is less than a lower limit value of said pulse current, and for outputting said pulse current command value in a case except the above; and
 a pulse frequency correction means for outputting a frequency correction value f_e to said pulse frequency control means, such that when said pulse current upper limit value or lower limit value is selected continuously in a predetermined number of times at said pulse current comparison and adjustment means, said pulse frequency is increased/decreased by a predetermined value Δf in accordance with said selected number of times.

2. A pulse arc welding apparatus according to claim 1, further comprising:

a pulse frequency reference value setting means for outputting a pulse frequency reference value corresponding to a wire feed rate; and
 a pulse frequency adding means for adding said pulse frequency reference value and a pulse frequency command value which is an output of said pulse frequency control means, and for outputting a pulse frequency added value f .
 3. A pulse arc welding apparatus according to claim 2, wherein said predetermined value Δf is a value which corresponds to an amount of either one of said pulse frequency reference value or said pulse frequency added value.
 4. A pulse arc welding apparatus according to claim 1, wherein said predetermined value Δf is a value which corresponds to a difference between said pulse current command value and said pulse current upper limit value, said pulse current lower limit value, or an output value of said pulse current setting means.
 5. An AC pulse arc welding apparatus for feeding a consumable electrode with a constant rate, for arc-welding by applying a welding current constituted of a pulse current of a constant voltage characteristic and a base current of a constant current characteristic and a straight polarity current between the consumable electrode and a workpiece, comprising:
 a pulse voltage detecting means for detecting a pulse voltage;
 a pulse voltage setting means for setting a pulse voltage;
 a pulse current control means for outputting a pulse current command value, based on a dif-

ference signal between said pulse voltage detecting means and said pulse voltage setting means;

a pulse current detecting means for detecting a pulse current;

a pulse current setting means for setting a pulse current;

a pulse frequency control means for outputting a pulse frequency command value, based on a difference signal between said pulse current detecting means and said pulse current setting means;

a pulse current upper and lower limit values setting means for outputting a pulse current upper limit value and/or lower limit value;

a pulse current comparison and adjustment means for inputting a pulse current command value and a pulse current upper limit value and/or a pulse current lower limit value, and for outputting said pulse current upper limit value, when said pulse current command value is larger than an upper limit value of a pulse current, and/or said pulse current lower limit value when said pulse current command value is less than a lower limit value of said pulse current, and for outputting said pulse current command value in a case except the above; and

a pulse frequency correction means for outputting a frequency correction value f_e to said pulse frequency control means, such that when said pulse current upper limit value or lower limit value is selected continuously in a predetermined number of times at said pulse current comparison and adjustment means, said pulse frequency is increased/decreased by a predetermined value Δf in accordance with said selected number of times.

6. A pulse arc welding apparatus according to claim 5, further comprising:

a pulse frequency reference value setting means for outputting a pulse frequency reference value corresponding to a wire feed rate and a straight polarity ratio; and

a pulse frequency adding means for adding said pulse frequency reference value and a pulse frequency command value which is an output of said pulse frequency control means, and for outputting a pulse frequency added value f .

7. A pulse arc welding apparatus according to claim 6, wherein said predetermined value Δf is a value which corresponds to an amount of either one of said pulse frequency reference value or said pulse frequency added value.

8. A pulse arc welding apparatus according to claim 5, wherein said predetermined value Δf is a value which corresponds to a difference between said pulse current command value and said pulse current upper limit value, said pulse current lower limit value, or an output value of said pulse current setting means.

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FIG. 1

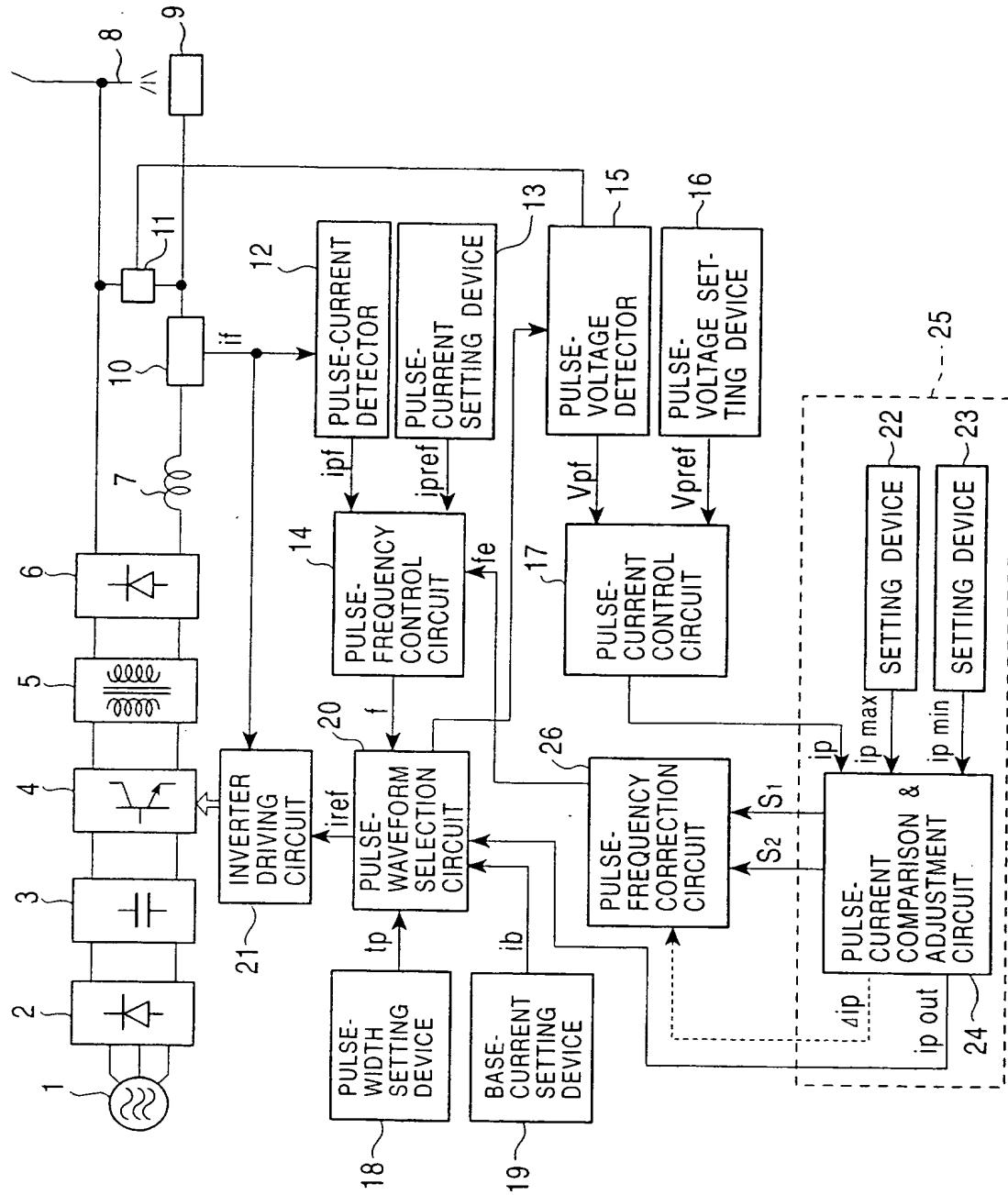


FIG. 2

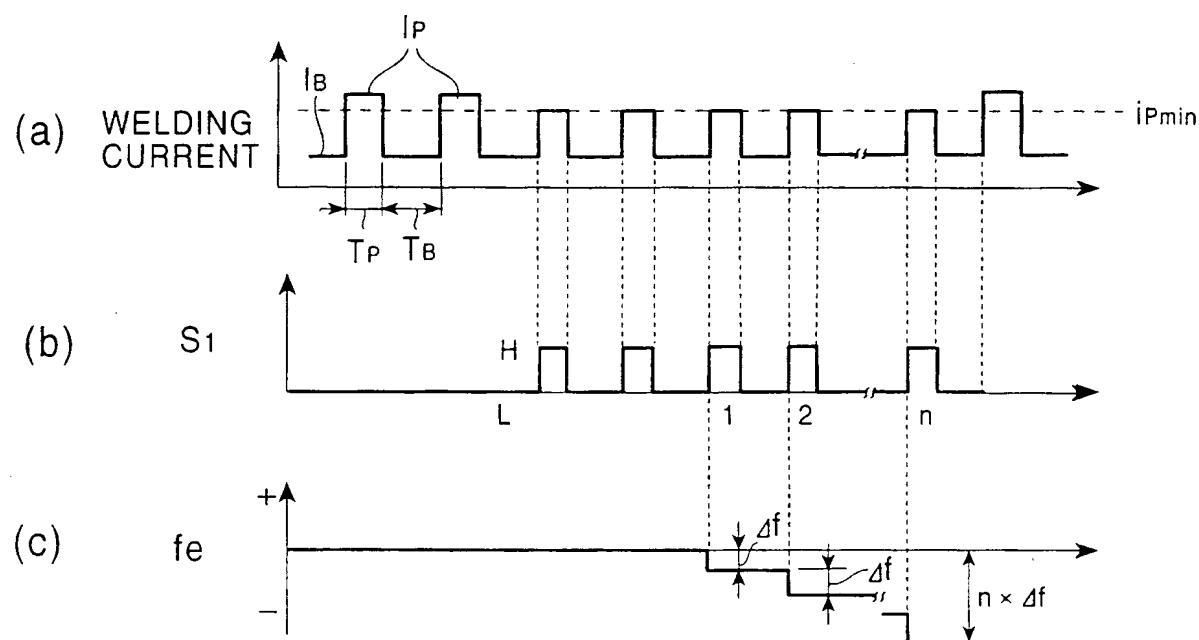


FIG. 3

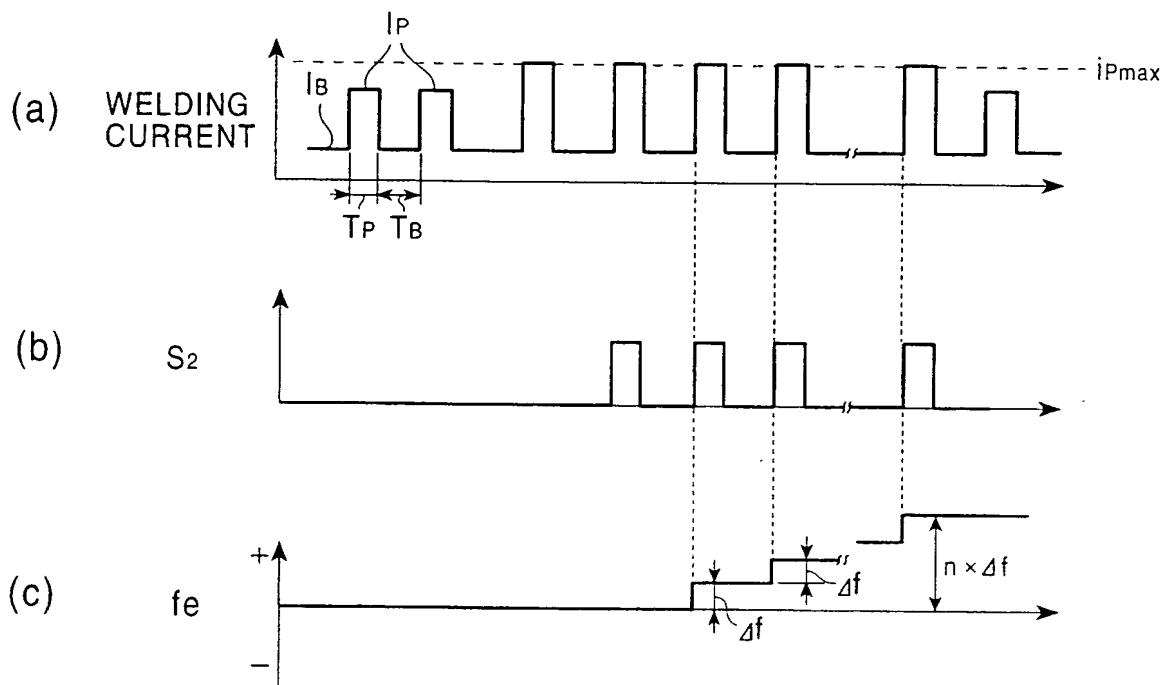


FIG. 4

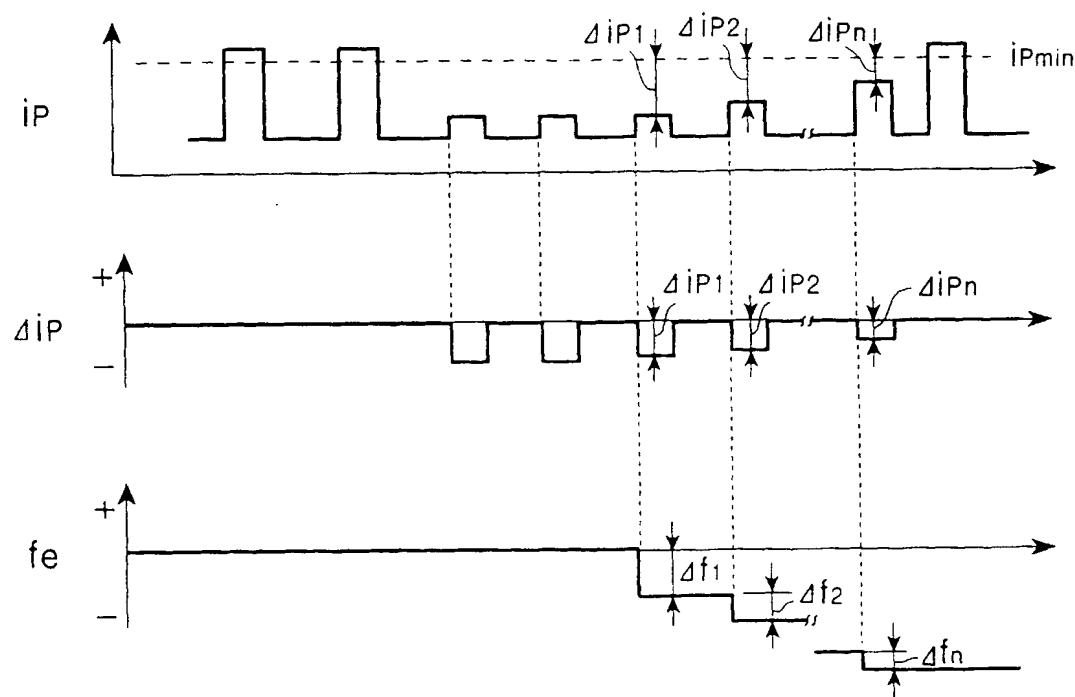


FIG. 5

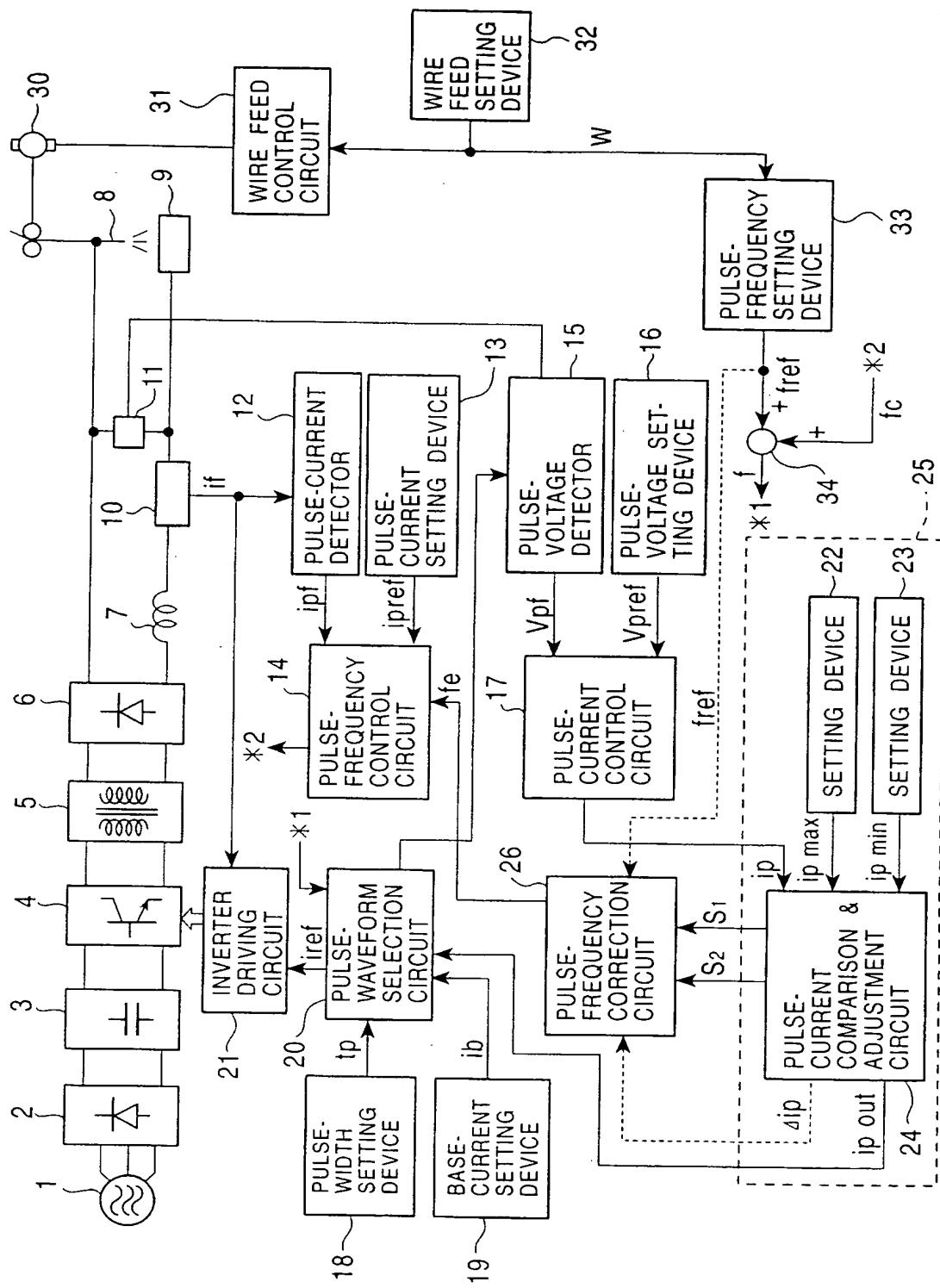


FIG. 6

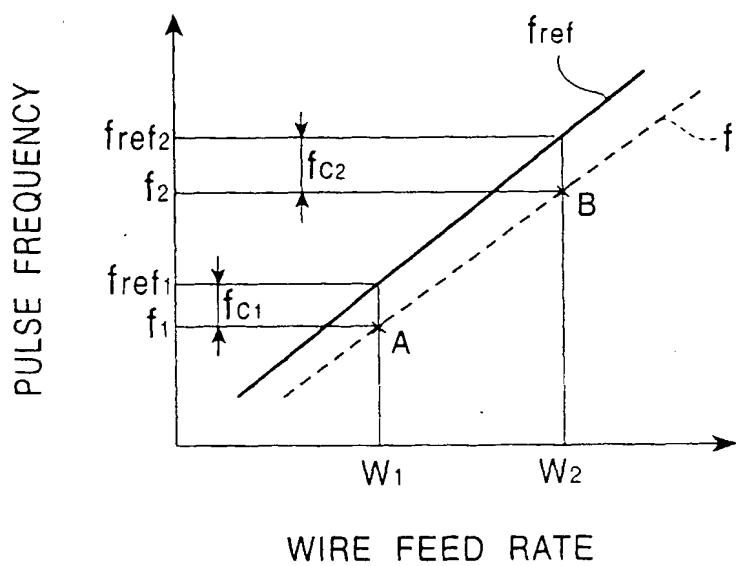


FIG. 7

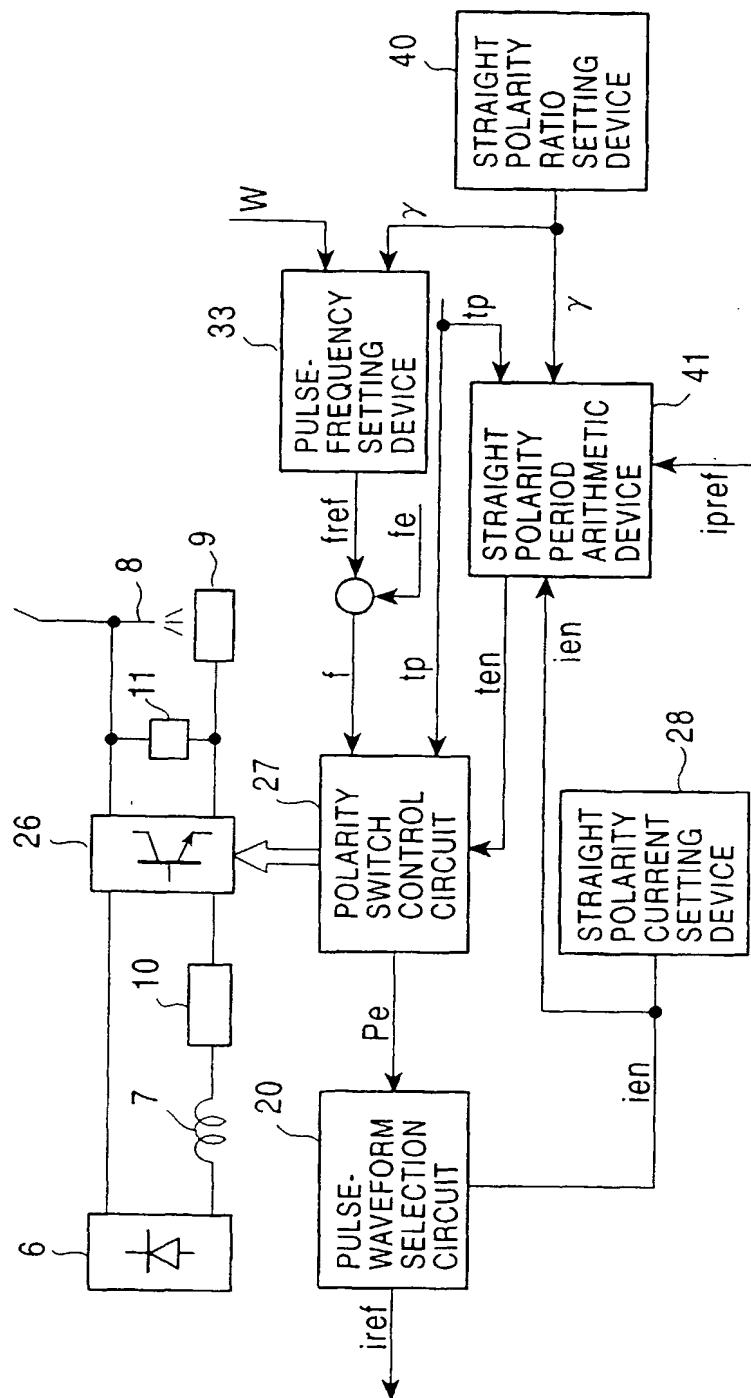


FIG. 8

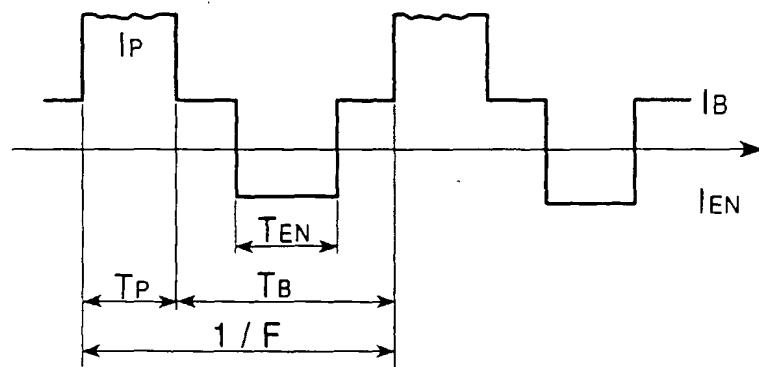
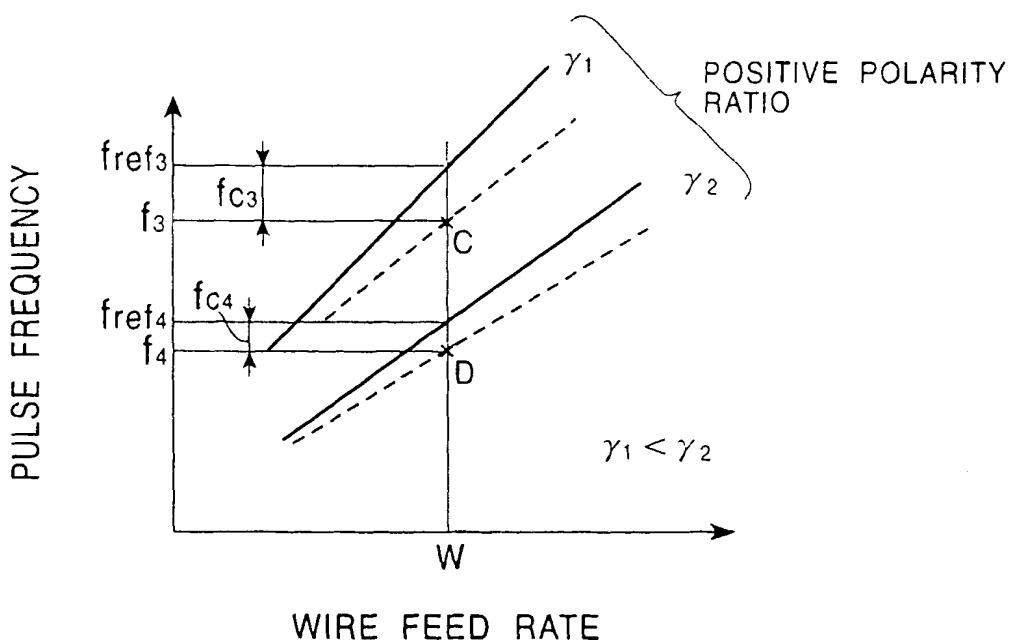


FIG. 9





European Patent
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EUROPEAN SEARCH REPORT

Application Number

EP 98 10 5744

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
D.A	PATENT ABSTRACTS OF JAPAN vol. 017, no. 298 (M-1425), 8 June 1993 & JP 05 023850 A (KOBE STEEL LTD), 2 February 1993. * abstract *-----	1-8	B23K9/09
TECHNICAL FIELDS SEARCHED (Int.Cl.6)			
B23K			
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
MUNICH	8 July 1998	Pricolo, G	
CATEGORY OF CITED DOCUMENTS			
<input checked="" type="checkbox"/> particularly relevant if taken alone <input checked="" type="checkbox"/> particularly relevant if combined with another document of the same category <input type="checkbox"/> technological background <input type="checkbox"/> non-written disclosure <input type="checkbox"/> intermediate document	<input type="checkbox"/> theory or principle underlying the invention <input type="checkbox"/> earlier patent document, but published on, or after the filing date <input type="checkbox"/> document cited in the application <input type="checkbox"/> document cited for other reasons <input type="checkbox"/> member of the same patent family, corresponding document		